

Date: Wednesday, 5/23/2007 3:24:31 PM
User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SADDLE SPACER |
| Job Number : 32469 | |
| Estimate Number : 11063 | |
| P.O. Number : <i>N/A</i> | Part Number : D2935 |
| This Issue : 5/23/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2935 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 31793 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 5/29/2007 Qty: 40 Um: Each |
| Checked & Approved By : <i>[Signature]</i> | |
| Comment : Est A 00-06-06 New Issue EC | |
| Est Rev:B Now 6061-T6 06-06-23 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s)
Material: M6061-T6 0.080" Thick
Batch *m104392*

ml 07 06 10

(40)

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D2935
Dwg Rev: *B*
Prog Rev: *B*

ml 07 06 10

[Signature] 07/06/21

(40)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 10

(40)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 07/06/18

(40)

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

[Signature]

07-06-28

(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/29

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:31 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 32469

Part Number: D2935

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 07/06/29 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/06/29 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

CP 07/06/29

Job Completion



U 07.06.29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

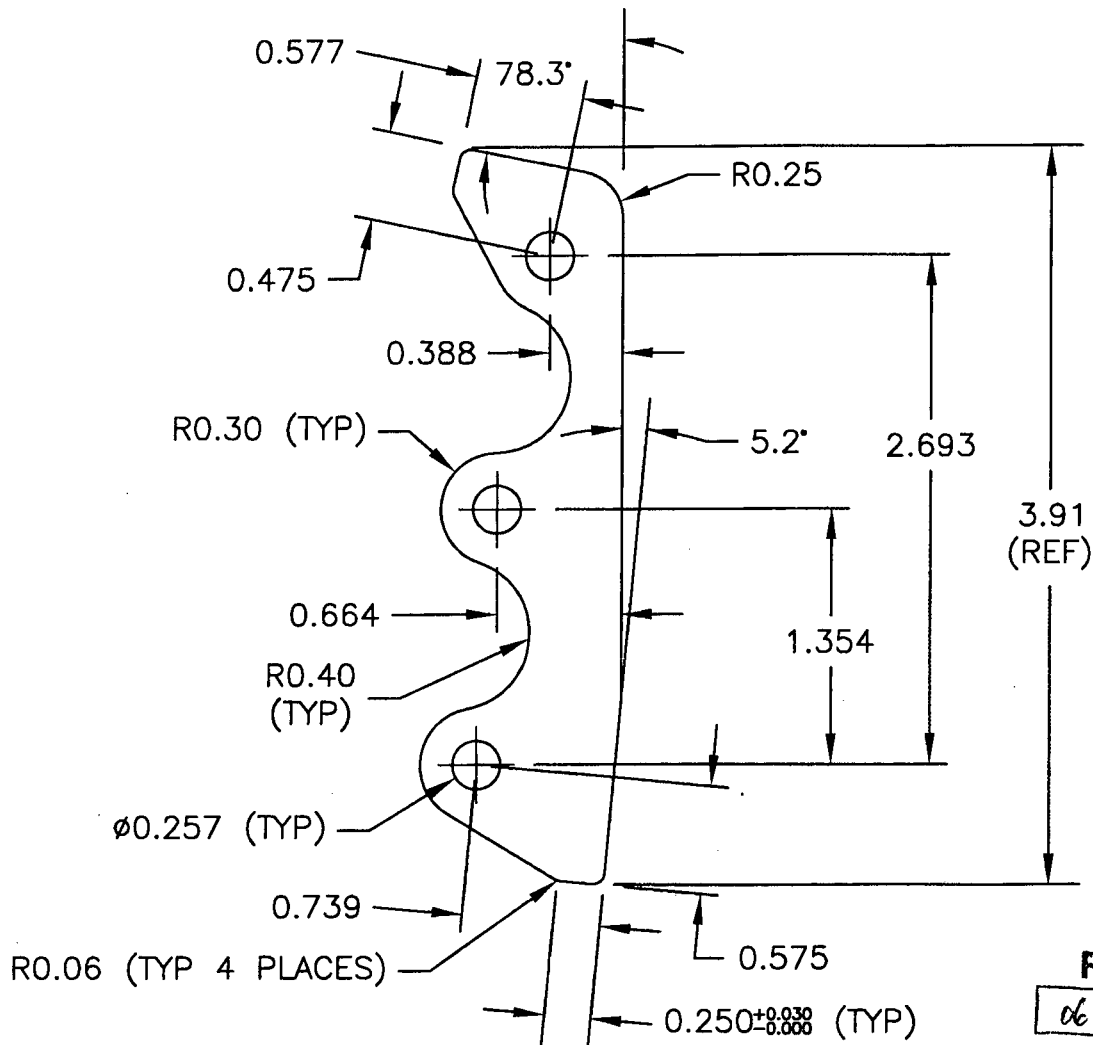
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|-------------------------|--|------------------------|
| DESIGN 77 | DRAWN BY C.B. | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED [Signature] | DRAWING NO. D2935 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE SADDLE SPACER | SCALE 1:1 |
| A | 99.11.02 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32469

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